

**Work Order ID 71010**

Tuesday, June 21, 2011 9:01:37 AM



Page 1

Item ID: D3294-1

Accept



Setup Start

Revision ID:

Item Name: Bracket

Stop



Start Date: 6/20/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

1/10/11-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3294

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2024.083

1-Cut as per Dwg D3294

CUt File D3294-3

Dwg Rev:

Prog Rev:

\*grain direction on a 45 deg as per dwg\*\*

2-Deburr if necessary

B11-6-21

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Setup Start



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Item Name: Bracket

Start Date: 6/20/2011 Start Qty: 8.00



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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



8 11/6/22

QC

Memo

Quality Control

130



Brake NC

Memo

Brake NC

1-Deburr if necessary  
2-Bend as per Dwg D3294  
(Ensure angle is correct)

0.00

0.00

SP 11/6/27

8

140



QC

QC5- Inspect part completeness to step on W/O

0.00

0.00

8 11/6/27

78

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

Item ID: D3294-1

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Setup Start



Revision ID:

Item Name: Bracket

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Start Date: 6/20/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				8	0	11-6-27	
Hand Finishing	Memo	0.00							
160  QC	QC3- Inspect Part Finish	0.00				8x	0	11/06/27	
Quality Control	Memo	0.00							
170  Small Fab		0.00							
Small Fab	Memo	0.00							
	1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294								

8x 0 11/06/27

11/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, June 21, 2011 9:01:37 AM

Page 4

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Accept

Revision ID:

Item Name: Bracket

Start Date: 6/20/2011 Start Qty: 8.00

Required Date: 6/20/2011 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulog 127

x8

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3.

0.00



Powdercoat

Memo

Start Time:

Oven Temperature:

Finish Time:

0.00

Powder Coating

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8x8 m-11/06/27

8 of 11 ul 11/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, June 21, 2011 9:01:38 AM



Page 5

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Stop



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Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Identify as per dwg & Stock Location: ST212

0.00



Packaging

Memo

0.00

Packaging

CY 11/04/28 (8)

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/28 J11-06-28 (5)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 9:01:44 AM

Page 1

Work Order ID: 71010

Parent Item: D3294-1

Parent Item Name: Bracket



Start Date: 6/20/2011

Required Date: 6/20/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP ☐ A ☐ 04.08.24 ☐ New issue ☐ KJ/JLM ☐  
 IPP Rev:B Now On Waterjet 07-03-26 JLM  
 IPP Rev:C 08-07-16 Redesign part DD verified by:EC  
 IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased		No		100	sf	110.1000	1.8	15.15789			



2024-T3 .080 sheet



B11-6-21

Location	Loc Qty	Loc Code
MAT022	110.1	
105411	6	
109424	4	
110347	0.5	
110908	3	
112331	3	
113796	7	
114025	17.2	
116604	5.8	
117392	63.6	

D3294-5

Manufactured No

170

Each

25.0000

1



Doubler



8  
6/21/06/27

Location	Loc Qty	Loc Code
GA	25	
68359	4	
69525	21	

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 9:01:44 AM

Page 2

Work Order ID: 71010



Parent Item: D3294-1



Parent Item Name: Bracket

Start Date: 6/20/2011

Required Date: 6/20/2011

Start Qty: 8.00

Required Qty: 8.00

MS20470AD4-5

Purchased

No

170

Each

790.0000

15

120



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

790

116893

790

*EF 6/20/27*  
120

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

71010  
~~71010~~

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Bracket Assembly		<b>Part Number:</b>	<b>D3294-1</b>
<b>Inspection Dwg:</b> D3294	<b>Rev:</b> C	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.129	✓		V	1B02
Ø0.141	+0.005/-0.001	.143	✓		V	
6.708	+/-0.010	6.714	✓		V	
1.118	+/-0.010	1.118	✓		V	
5.590	+/-0.010	5.594	✓		V	
1.118	+/-0.010	1.118	✓		V	
13.563	+/-0.010	13.563	✓		T	1B01
1.043	+/-0.010	1.043	✓		V	
0.625	+/-0.010	.623	✓		V	
0.325	+/-0.010	.323	✓		V	
0.300	+/-0.010	.300	✓		V	
0.400	+/-0.010	.400	✓		V	
6.000	+/-0.010	5.999	✓		V	
1.000	+/-0.010	1.000	✓		V	
17.124	+/-0.010	17.125	✓		T	
16.13	+/-0.030	16.13	✓		T	
7.27	+/-0.030	7.272	✓		V	
11.97	+/-0.030	11.975	✓		P	
8.37	+/-0.030	8.371	✓		P	
20.05	+/-0.030	20.05	✓		T	
12.98	+/-0.030	12.98	✓		T	
14.59	+/-0.030	14.59	✓		T	
11.66	+/-0.030	11.66	✓		T	
0.080	+/-0.010	.080	✓		V	

<b>Measured by:</b> <u>RB</u>	<b>Audited by:</b> <u>S</u>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <u>11-6-21</u>	<b>Date:</b> <u>11/04/22</u>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	<u>[Signature]</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

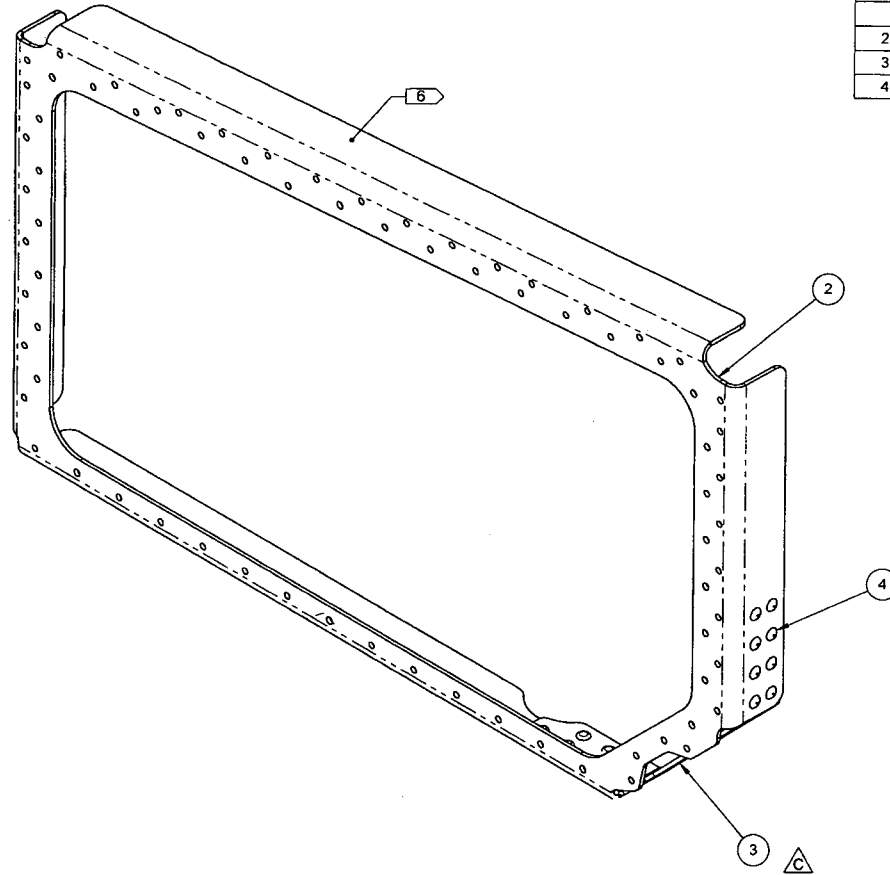
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ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



**D3294-1 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOR-COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71010

*11-0621* **RELEASED**  
*09/07/11 JWP*

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3294	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	09.03.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

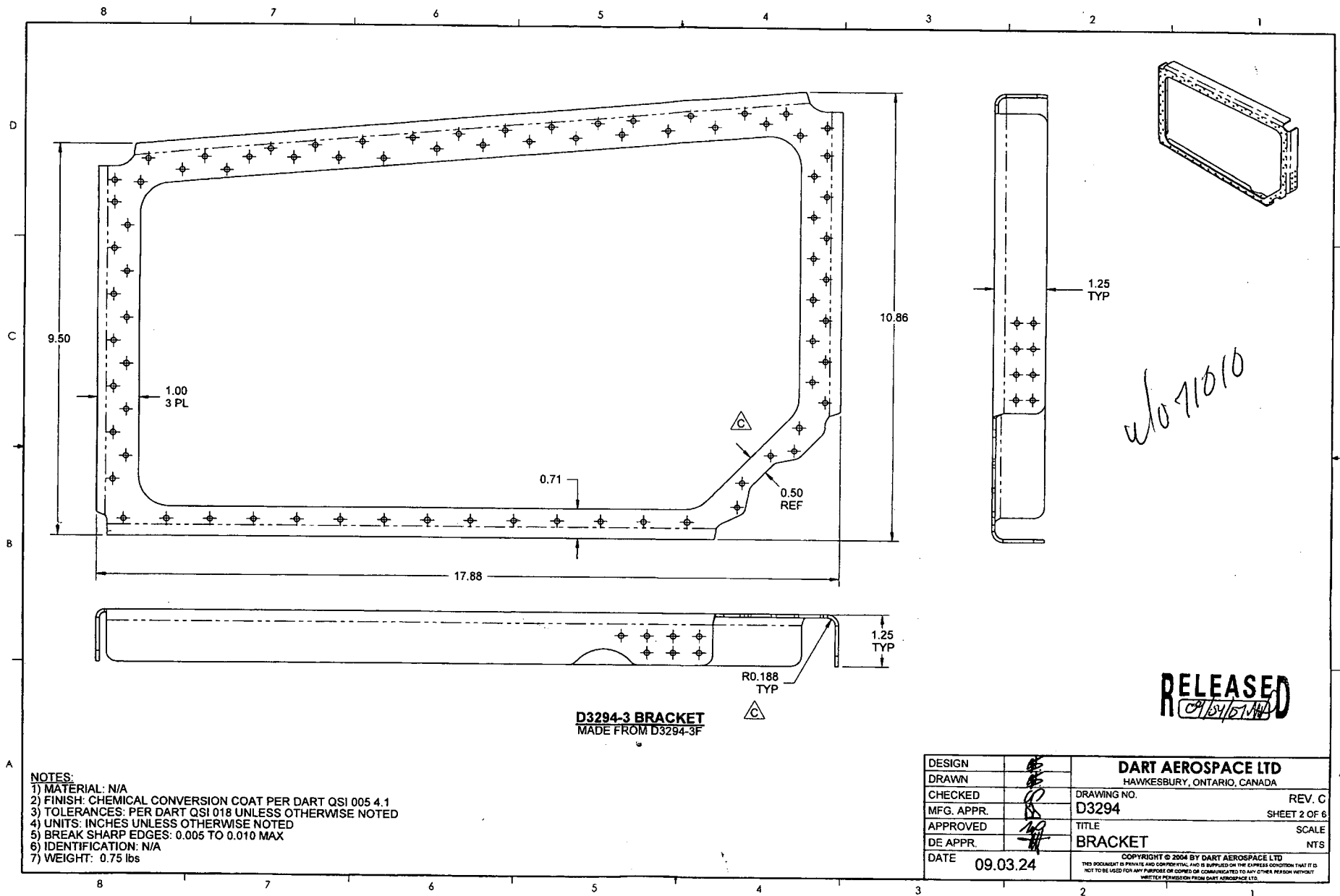
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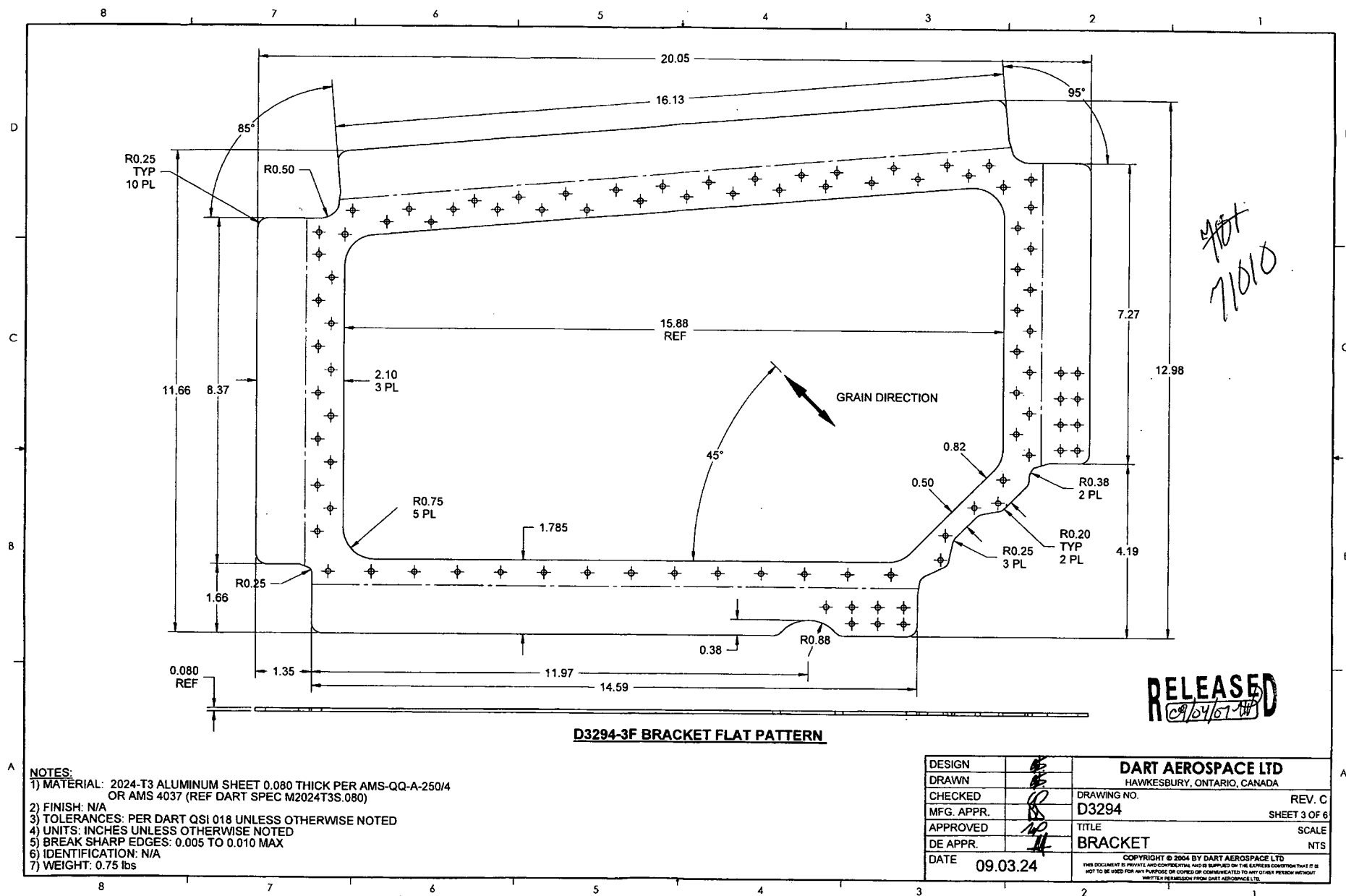
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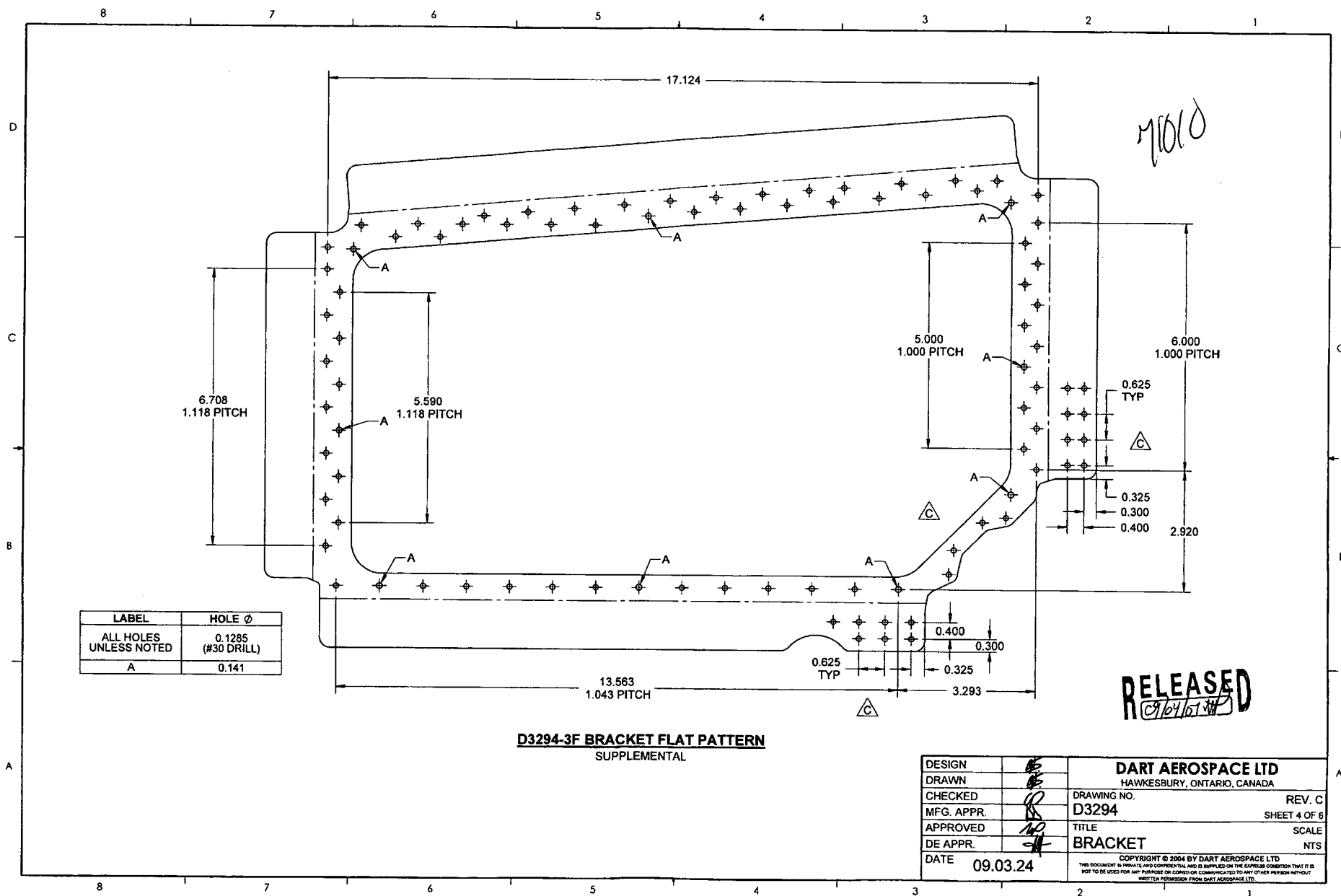
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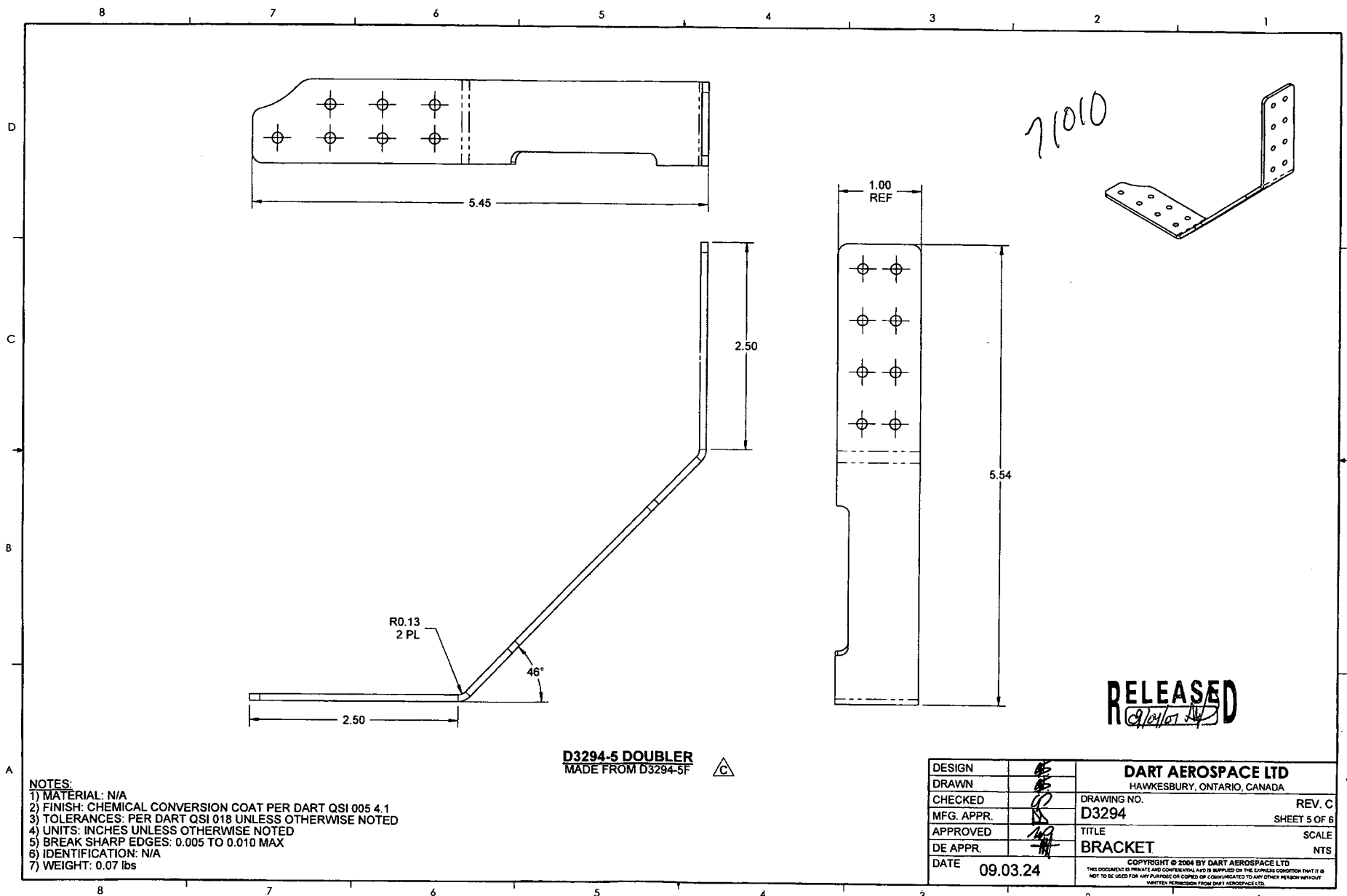
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**NOTE:** Date & initial all entries





- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.07 lbs

**D3294-5 DOUBLER**  
MADE FROM D3294-5F

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.03.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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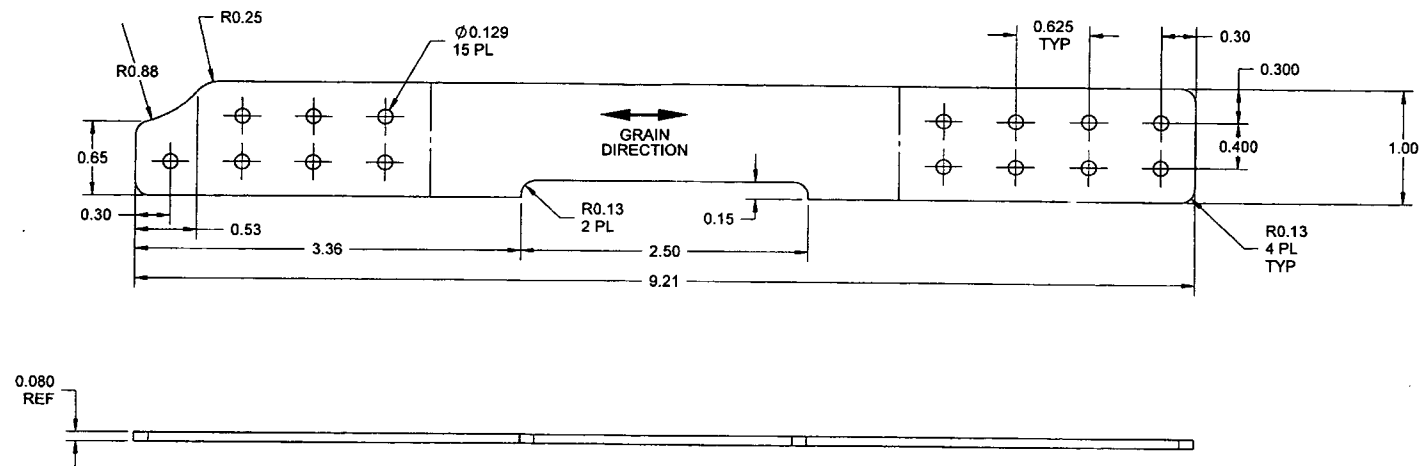
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**NOTE:** Date & initial all entries

11010



D3294-5F DOUBLER FLAT PATTERN



RELEASED  
09/04/07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			D3294	SHEET 6 OF 6
APPROVED			TITLE	SCALE
DE APPR.			BRACKET	NTS
DATE	09.03.24		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE BASIS OF CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries